



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4653-7

Job Sheet 167180



Part No: D4653-7

Job Qty: 160 ea

Part Name: Fitting, Large



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/25/17

Job Tracking No:

Due Date: 11/10/17

Created By: Mario Poulin

Type: Stock

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	160 Ea		11/8/17	0.00	0.00	Start Up Machining	
100	Doosan	160 pcs		11/10/17	0.26	29.57	Doosan	
120	QC	160 pcs		11/10/17	0.00	0.00	QC8	
130	Packaging	160 pcs		11/10/17	0.00	0.00	Packaging3	
140	QC21-SA	160 Ea		11/10/17	0.00	0.00	QC21	

DAS
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9-68

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M6061T6R1.000	3	22	0	0

M6061T6R0.875

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Large Fitting	1.380Inches ± 0.030	1.410 1.350		
2	Large Fitting	0.250Inches ± 0.010	0.260 0.240		
3	Large Fitting	45.000Degrees ± 0.500	45.500 44.500	Angle	
4	Large Fitting	0.940Inches ± 0.030	0.970 0.910	Radius	
5	Large Fitting	2.120Inches ± 0.030	2.150 2.090		
6	Large Fitting	0.825Inches ± 0.010	0.835 0.815	Diameter	
7	Large Fitting	0.547Inches ± 0.010	0.557 0.537	Diameter	
8	Large Fitting	0.990Inches ± 0.010	1.000 0.980		
9	Large Fitting	0.745Inches + 0.000 - 0.005	0.745 0.740	Diameter	

Plex 10/25/17 3:12 PM dart.poulin.mario

30.93

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____ Date : _____ Description	DISPOSITION Rework ☐ Scrap ☐ Use as is ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Cross tube ☐ Small Fab ☐ Water Jet ☐ Prod. Eng. Coord. ☐ /Packaging ☐ Supplier ☐	 S005392 Fitting, Large PART NO: D4653-7 Revision: Operation: Start up Operation Quantity: 130 Change No: Mfg Date: 11/02/17 Job No: 167180																																																																																																																							
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